



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW109-3501-08-115

Job Sheet 174832



Part No: RBW109-3501-08-115

Job Qty: 3 Ea

Part Name: Adapter, Landing Gear Shockstruts Nitrogen Charge



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/22/18

Job Tracking No:

Due Date: 4/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW109-3501-08-115 Rev 3 IPP Rev A 18.02.14 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	3 pcs	4/6/18	4/6/18	0.00	0.00	Purchasing		AT 18/04/25
110	Packaging	3 pcs	4/6/18	4/6/18	0.00	0.00	Packaging2		AT 18/04/25
120	QC	3 pcs	4/6/18	4/6/18	0.00	0.00	QC6		11 APR 26 2018
130	Packaging	3 pcs	4/6/18	4/6/18	0.00	0.00	Packaging3		9 APR 26 2018
140	QC21-FG	3 Ea	4/6/18	4/6/18	0.00	0.00	QC21		GA 106

Part Op 100 - Issue P/O: 39419 MANUFACTURE RBW109-3501-08-115 AS PER DWG Supplier: METEC ***NOTE***

Descriptions: Ensure solder joint is clean of all debris. Soldered joint must hold 1500psi of nitrogen charge. Certificate of conformity is required

MAR 23 2018

APR 26 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW109-3501-08-115P	Adapter, Landing Gear Shockstruts Nitrogen Charge	3 Ea (1 ea)	100-Purchasing	5065211

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW109-3501-08-115P	3	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

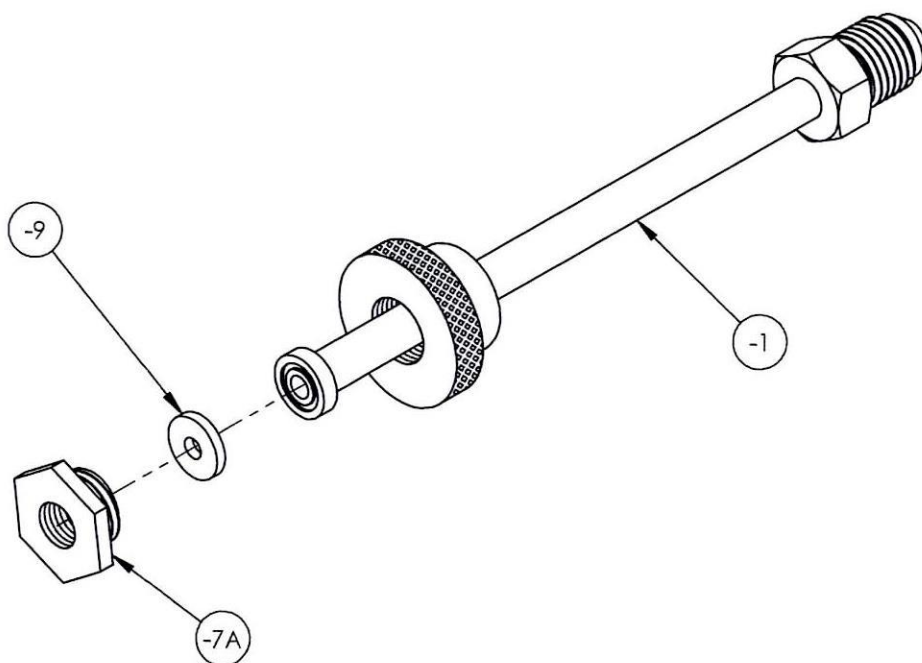
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Desc: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐	AGAINST DEPARTMENT/PROCESS Water Jet ☐ Engineering ☐ Prod. Eng. Coord. ☐ Quality ☐ ec/Store/Packaging ☐ Other ☐ Supplier ☐ Container No: S065214 Adapter, Landing Gear Shockstruts Nitrogen Change PART NO: RBW109 – 3501 – 08 – 115 Serial No/Batch: S065214 Revision: Operation: Packaging Change No: Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632 – 5200 Email: sales@dartaero.com www.dartaerospace.com Mfg Date: 04/25/18 Job No: 174832
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		MERGED -7, -8 & -9 INTO -7 AS BUYOUT. DELETED PAGE 4. -5 CH'D TUBE DIMENSIONS, WAS $\varnothing.180/\varnothing.250$, IS $\varnothing.210/\varnothing.280$.	9/14/2010	WP	DW
2		-5 CH'D MATERIAL FROM BRASS TO 303/304, ADDED EXTRA GASKET RELIEF. MERGED -7, -9, AND -11 INTO -7 ASSEMBLY.	9/20/2010	WP	DW
A2		CORRECTED P/N WAS RBW109-351-08-115 IS RBW109-3501-08-115. -5 CH'D ID FROM $\varnothing.115$ TO $\varnothing.156$.	6/26/2012	JAG	SE
2A		UPDATED SHEET FORMATS AND DRAFTING STANDARDS. SEPARATED -3 & -5 TO INDIVIDUAL SHTS. ADDED -7A TO BOM.	10/16/2013	CFS	RW
3	16-0208	-3 CH'D DIM WAS $\varnothing.24 \pm .001$ IS $\varnothing.242 \pm .001$. -5 CH'D DIM'S WAS $\varnothing.156$ IS $\varnothing.135 \pm .030$, WAS $\varnothing.240$ (S.F. -3) IS $\varnothing.240 +.000/-0.002$ (S.F. -3), WAS $\varnothing.375$ IS $\varnothing.38$. DELETED NOTE 1 SHEET 1.	11/2/2016	RJC	JAG



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	SOLDER ASSY.			2
	1		-3		FLARED FITTING, 37°	316 S.S.	7/16-20 FOR 1/4 OD TUBE (MCMMASTER-CARR #50715K522) MODIFIED	3
	1		-5		TUBE	304 S.S.		4
	1		-7		FITTING, THUMB NUT		(AIRCRAFT SPRUCE #06-11700 SCHRADER #6116) MODIFIED	2
			-7A	1	FITTING, HEX NUT		PART OF -7	1
		B/O	-9	1	GASKET	HARD FIBER	(AIRCRAFT SPRUCE #SK2043-5)	1
	ASSY -1							

DART AEROSPACE	
TITLE ADAPTER, L/G SHOCKSTRUTS NITROGEN CHARGE	
DWG NO. RBW109-3501-08-115	REV 3
MAT'L HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: PERRITT CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL AGUSTA AW139	
SCALE 1:1	DATE 4/23/2010
SHEET 1 OF 4	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039419**

Supplier: WEJ001-VC
Wejay Machine Products Co. Ltd
600 O'Connor Drive
Kingston
ON
K7P 1N3 Canada
Phone: 613-384-1662
Fax: 613-384-2997

PO No: PO039419

PO Date: 3/23/18

Due Date: 5/2/18

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

E-MAILED
MAR 28 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments: quotation no. wj-9913

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	RBW109-3501-08-115P			Adapter, Landing Gear Shockstruts Nitrogen Change As Per Dwg RBW109-3501-08-115 Rev. 3	Firmed	5/2/18	3 Ea	2x 0 Ea	3 Ea	\$498.00/Ea	\$1,494.00

Line Item Note job no. 174832

Grand Total: \$1,494.00

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/28/18 12:58 PM dart.lavoie.chantal

DAS
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NO GOODS RETURNED WITHOL
PRIOR AUTHORIZATION